

Thursday, March 03, 2011 11:56:03 AM

Page 1



Accept

**Setup Start**

Stop



Start Date: 3/3/2011 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

Run Start



QC:




Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3957	A								
100	Pick Kit	0.00							
									
Packaging									
Packaging	Memo	0.00							
110		0.00							
									
Small Fab									
Small Fab	Memo	0.00							
	1-Install Helicoil in d3957-1								
	2-Install Rod end and Nut Loosely								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC									
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67025

Thursday, March 03, 2011 11:56:03 AM



Page 2

Item ID: D3957-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Assembly, Door LH Upper

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 100

0.00



Packaging

Memo

0.00

Packaging

4/10/11 2 (1)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11 (1)11-04-7 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 11:56:10 AM

Page 1

Work Order ID: 67025

Parent Item: D3957-041

Parent Item Name: Hinge Assembly, Door LH Upper

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3518-3 Stainless Steel Ball Joint Rod End		Manufactured	No			100	Each	4.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST064 39029 ✓ 4

MS124818 Helicoil		Purchased	No			100	Each	14.0000	1	1			
----------------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST314 112503 ✓ 14

D3957-1 Hinge, Door LH Upper		Manufactured	No			100	Each	0.0000	1	1			
---------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

NAS509-6 Nut		Purchased	No			100	Each	14.0000	1	1			
-----------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST280 113537 ✓ 14

67024

m-l 11/04/06

IX m-l 11/04/06

IX m-l 11/04/06

m-l 11/04/06

IX

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

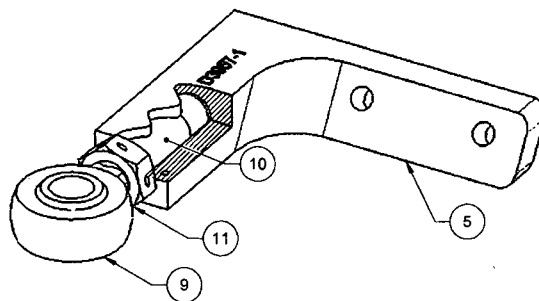
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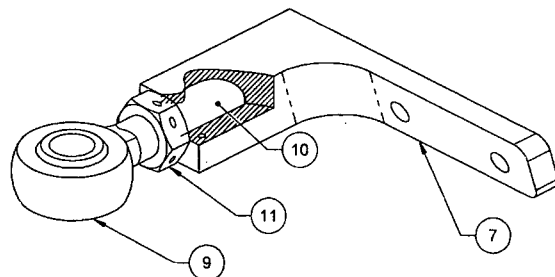
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



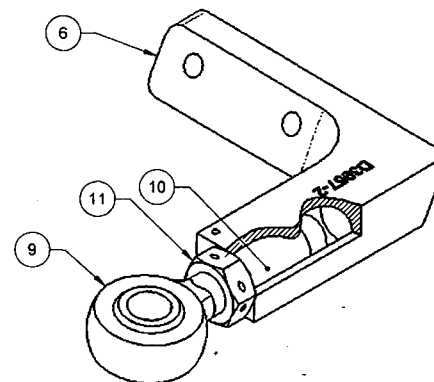
D3957-041 HINGE ASSY, DOOR LH UPPER



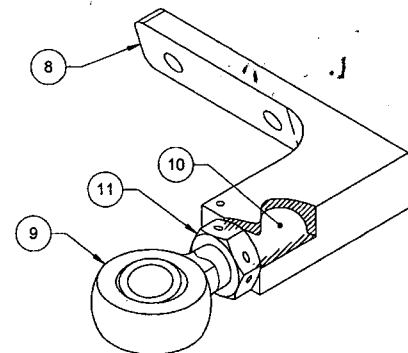
D3957-043 HINGE ASSY, DOOR LH LOWER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67025

PH11-033



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

RELEASED
2009-10-08
AWD

A	NEW ISSUE	09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3957 TITLE HINGE SCALE NTS
DRAWN	<i>AS</i>	
CHECKED	<i>PH</i>	
MFG. APPR.	<i>21</i>	
APPROVED	<i>149</i>	
DE APPR.	<i>149</i>	REV. A SHEET 1 OF 5
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

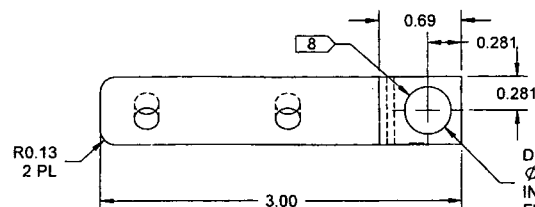
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

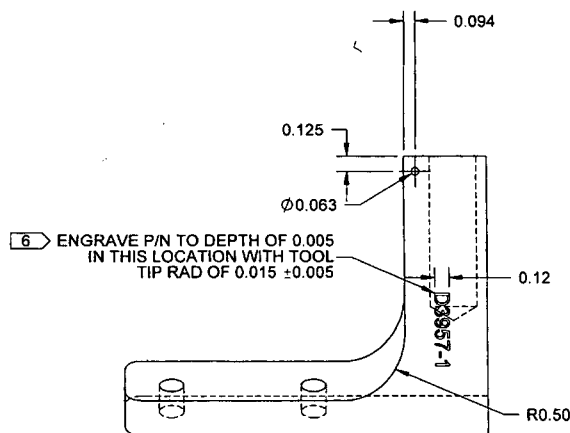
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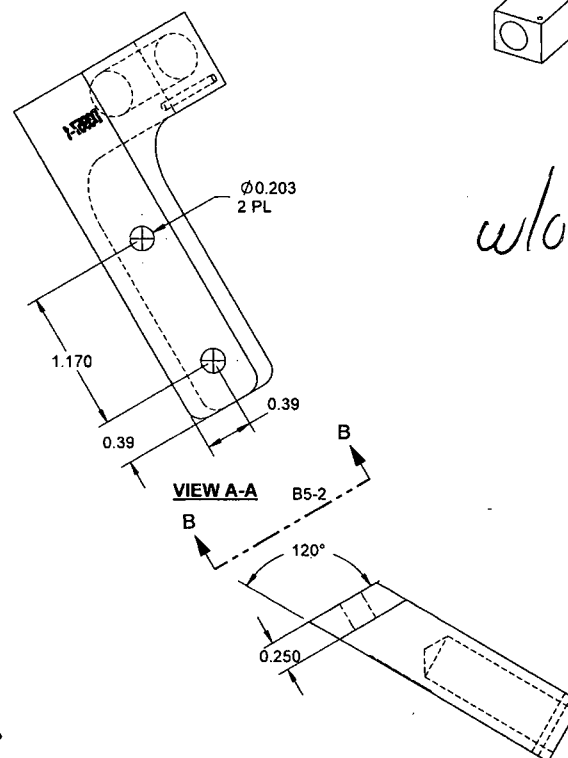
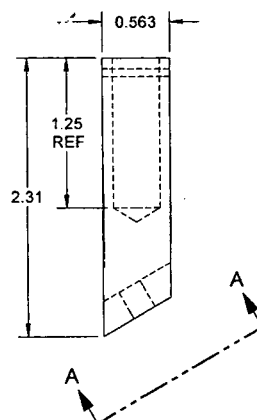
NOTE: Date & initial all entries



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



VIEW B-B

w/o 67625

D3957-1 HINGE, DOOR LH UPPER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

C3-2

RELEASED
 2009-10-08

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	SL	D3957	SHEET 2 OF 5
APPROVED	SL	TITLE	SCALE
DE APPR.	SL	HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

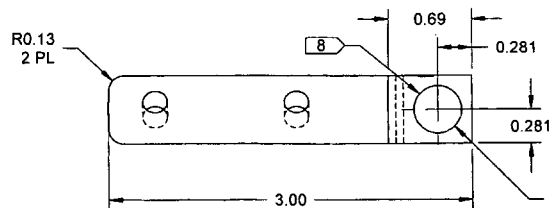
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

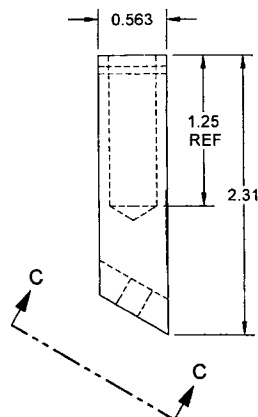
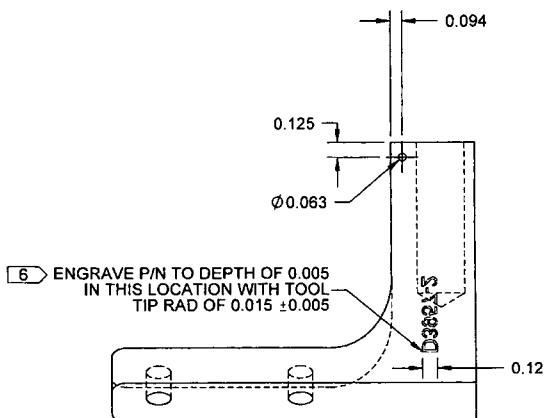
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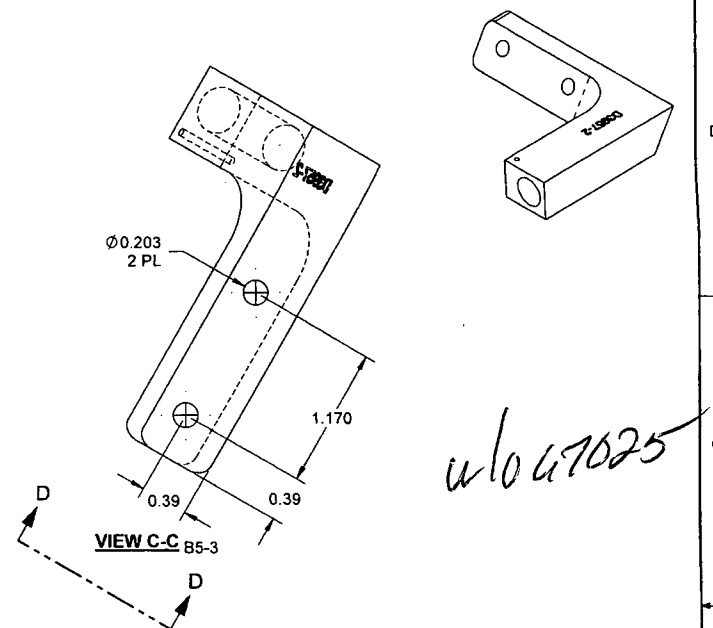


DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE

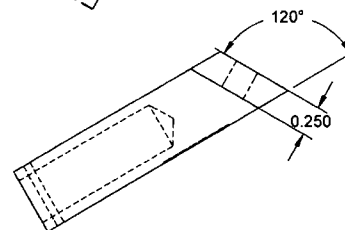
C



D3957-2 HINGE, DOOR RH UPPER



VIEW C-C B5-3



VIEW D-D

C3-3

RELEASED
 2009-10-08
 JMD

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

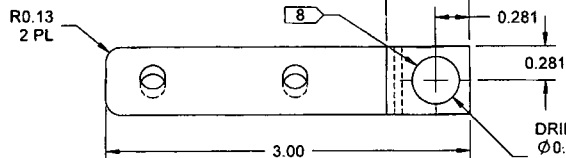
W/O:		WORK ORDER CHANGES						
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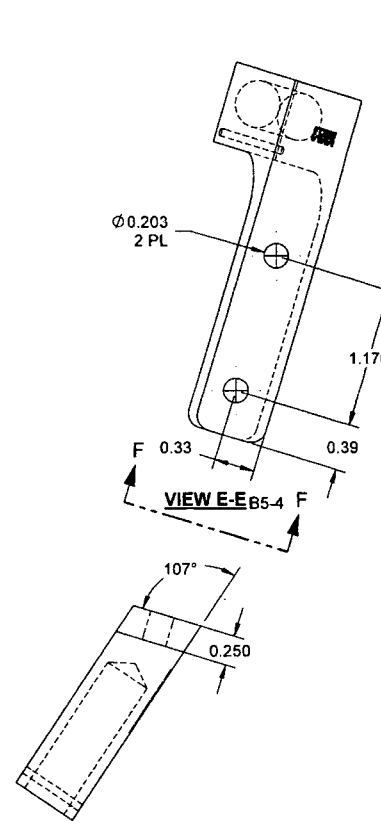
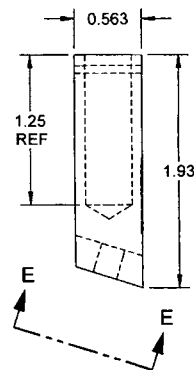
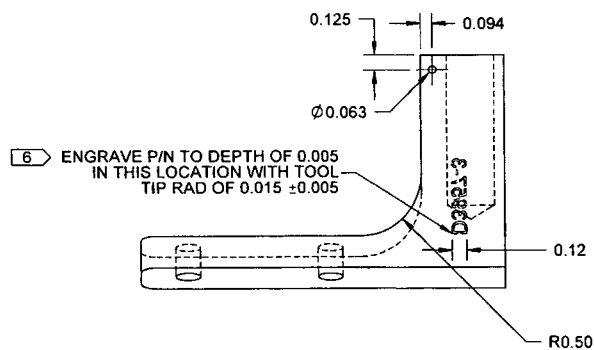
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



VIEW F-F C3-4

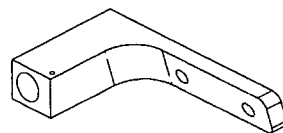
D3957-3 HINGE, DOOR LH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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RELEASED
 2009-10-08
MD



u/o 67025

W/O:		WORK ORDER CHANGES						
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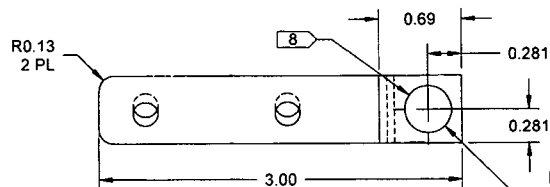
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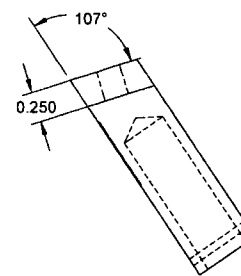
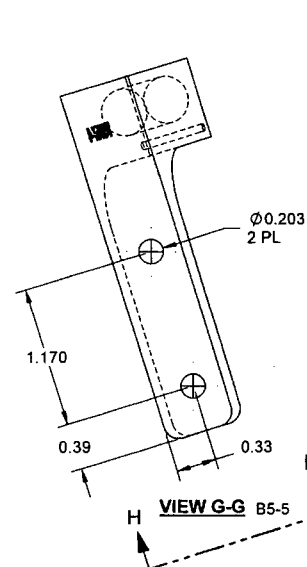
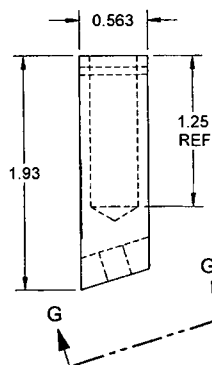
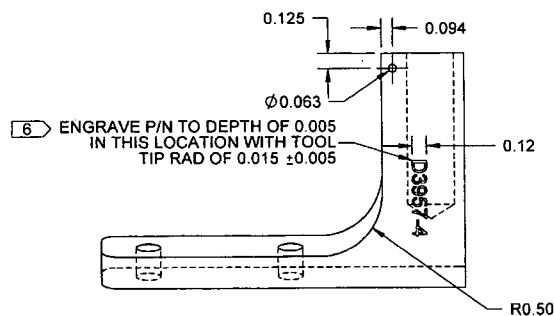
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8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



WLOG 7025

D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
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 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
 2009-10-08

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 5 OF 5
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HINGE	NTS
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8 7 6 5 4 3 2 1

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